

Date: Thursday, 12/13/2007 2:42:25 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36340	
Estimate Number : 12825	
P.O. Number : <u>NA</u>	Part Number : D3578041
This Issue : 12/13/2007 S.O. No. : <u>NA</u>	Drawing Number : D3578 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 35737	Material : <u>NA</u>
Written By : <u>[Signature]</u>	Due Date : 1/10/2008
Checked & Approved By : <u>[Signature]</u>	Qty: <u>40</u> Um: <u>20</u> Each
Comment : Est: A 07.04.11 New issue EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.1470 sf(s)
6061-T6 sheet 0.080"
(M6061T6S080)
Batch: 106320 B07-12-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3578 (Run prog. D3578-1)
Dwg Rev: A
Prog Rev: A B07-12-14

2-Deburr if necessary

[Signature] 07/12/17 (52)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07/12/17 (52) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Open rivet holes to 0.098" and C'sink as per dwg D3578

[Signature] 07/12/17 58 07-12-17 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:42:25 PM
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Drawing Name: DOUBLER

Job Number: 36340

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cauts
7/12/12 (52)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ 07-12-17 (X52)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. A. 07/12/17 (52X)

9.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nutplate

Batch: *M18057* (12X)

M106576 (40) 07/12/18

10.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

M1563

07/12/18

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

07/12/18 (52)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cauts
5 2/12/19 (452)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/12/19 54 (52X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:42:25 PM
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Drawing Name: DOUBLER

Job Number: 36340

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

2 07/12/19

Job Completion



W 07/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

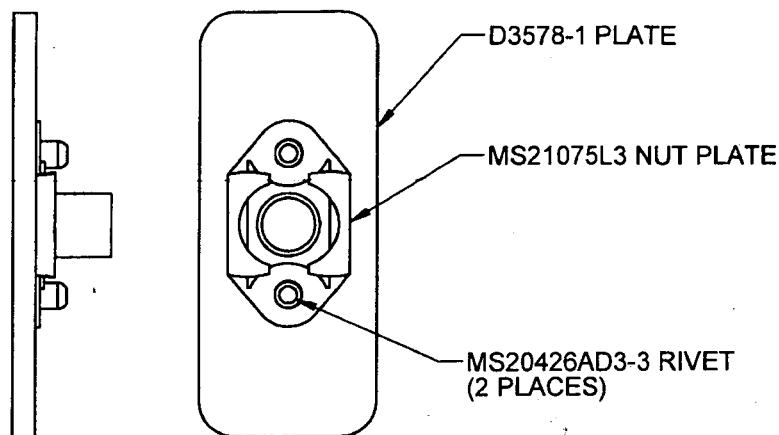
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

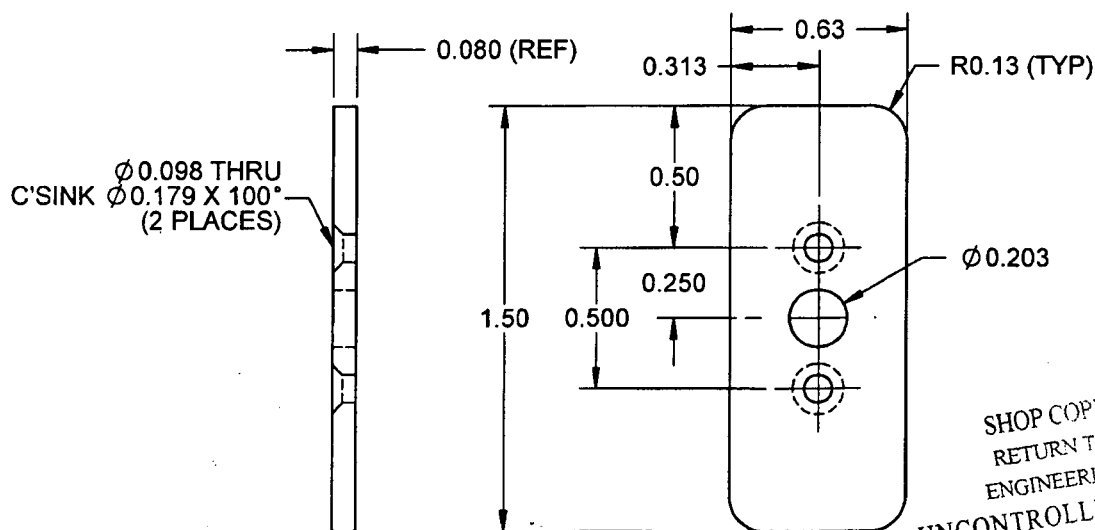
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**
07.04.02 #8**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36340

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